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Describes a heating control system for a screed assembly of a paving machine. The heating control system includes a plurality of resistive heating elements 50 to 56, arranged in pairs with the two heating elements of each pair being connected to a common output switch to 100 to 106, 110 to 116. It appears, however, that each heating element is a complete usual heating element, for instance of the type as described in German Utility Model No. 202 12 328, and not a number of heating coils (provided in the same casing) the power ratings of each individual heating coils sum up to the nominal heating power.

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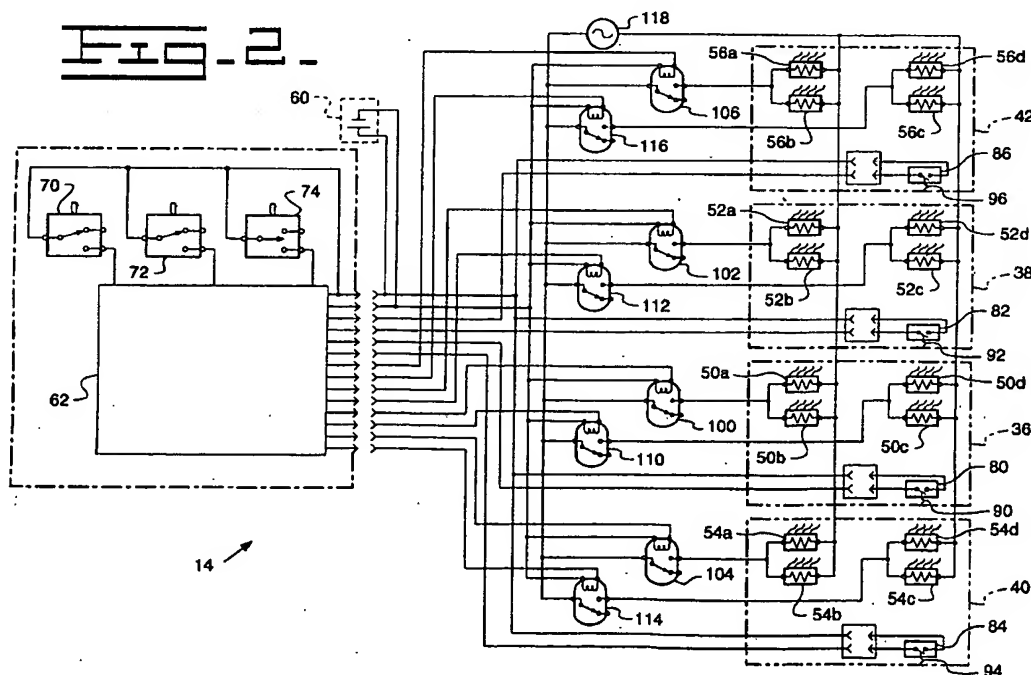
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(54) Heating control system for a screed

(57) A heating control system (14) for a screed assembly (10) of a paving machine (12) is provided. The heating control system (14) includes a plurality of resistive heating elements (50a-d, 52a-d, 54a-d, 56a-d) positioned adjacent to a screed plate (36, 38, 40, 42) of the screed assembly (10). An electrical power supply (118) is selectively connected with the resistive heating elements (50a-d, 52a-d, 54a-d, 56a-d) via switches

(100, 102, 104, 106, 110, 112, 114, 116) operated by a controller (62). The controller is responsive to inputs from at least manual switches (70, 72, 74) and temperature sensors (90, 92, 94, 96). The controller (62) is configured to automatically adjust the temperature of the screed plate (36, 38, 40, 42) by selectively energizing fewer than all of the resistive heating elements (50a-d, 52a-d, 54a-d, 56a-d) at a time.



Description

Technical Field

[0001] The invention relates to paving machines and, more particularly to a heating control system for a screed of a paving machine.

Background

[0002] Paving machines are generally used for laying a heated paving material, such as bituminous aggregate mixtures or asphalt, onto a roadbed and spreading the heated paving material to achieve a road with a uniform, smooth surface. After the heated asphalt is laid it is compacted and cools so that the road becomes passable by vehicles.

[0003] The paving machines include a screed assembly for spreading the heated material. The screed assembly has one or more screed plates, and these screed plates are at times heated for ease in manipulating the heated paving material. The temperature of the screed plates is important, because if the temperature is too high, the screed may warp or the heated paving material may be damaged. Also, if the temperature is too low, the heated paving material adheres to the screed and is difficult to spread and compact. Generally, the screed plates should be heated to a temperature close to the temperature of the heated asphalt material.

[0004] Controllers have been developed for controlling the temperature of the screed plates. Published patent application WO 00/47822 is directed to a heating control system that automatically regulates the screed plate temperature by adjusting current flow through resistive heating elements for each of the screed plates. However, when the temperature of a screed plate drops below a predetermined value, the entire screed plate is heated even though only a section of the screed plate may require heating. In addition, several screed plates may be heated simultaneously. Heating the entire screed plate or several screed plates simultaneously drains the power supply, which is used for other functions, such as lighting, of the paving machine, and such general heating is inefficient.

[0005] The present invention is directed to overcome one or more of the problems as set forth above.

Summary of the Invention

[0006] A heating control system for heating a screed assembly of a paving machine is provided. The screed assembly includes a screed plate. The heating control system includes a plurality of resistive heating elements attached to the screed assembly and positioned adjacent to the screed plate. An electrical power supply is connected to the plurality of resistive heating elements. A controller is connected to the plurality of resistive heating elements to automatically adjust the temperature of

the screed plate by selectively energizing one or more of the plurality of resistive heating elements.

[0007] A method for heating the screed assembly includes sequentially and automatically energizing one or more of the plurality of resistive heating elements at a time to achieve a predetermined screed plate temperature.

Brief Description of the Drawings

[0008]

FIG. 1 illustrates a screed assembly, embodying the present invention, that is towed by an asphalt paving machine;

FIG. 2 is a schematic view of a screed heating control system of the present invention; and

FIG. 3 is a flow diagram illustrating a method of operation of the heating control system of the present invention.

Detailed Description

[0009] A screed assembly 10 for a paving machine 12, only a portion of which is, is shown in FIG. 1. The paving machine 12 includes a heating control system 14 as shown in Fig. 2. The screed assembly 10 includes a main screed 16 and left and right screed extensions 18,20. It should be understood that left and right screed extensions 18,20 are shown as being front mounted but can be either front or rear mounted extensions. In an extended mode the left and right screed extensions 18,20 extend outwardly from either side of the main screed 16.

[0010] The main screed 16 is made up of first and second sections 30,32 one on each side of a longitudinal central axis 34. The left and right screed extensions 18,20 are slidably mounted to first and second sections 30,32 of the main screed 16 respectively and include first and second screed plates 36, 38. The left and right screed extensions 18,20 also include left and right screed plates 40,42.

[0011] The screed assembly 10 functions to spread paving material distributed by the paving machine 12 onto a roadbed. In order to achieve optimum workability of the paving material, the temperature of the screed plates 36,38, 40,42 should be maintained within a predetermined temperature range. This predetermined temperature range is for exemplary purposes, between 250-310°F, however, other temperature ranges may be set. The heating control system 14 automatically controls the temperature of screed plates 36,38, 40,42 and is illustrated in detail in FIG. 2.

[0012] The heating control system 14 includes resistive heating elements 50a-50d, 52a-52d, 54a-54d, 56a-56d, an electrical power supply 60 and a controller 62. Power supply 60 is any suitable AC or DC power source that is connected, as by wire, to the controller 62. The

power supply 60 shown in Fig. 2, utilizes a 24V DC power supply, but other voltages and power sources may be used, as would be known in the art. The controller 62 may include a typical microprocessor and memory, and can be programmed or hard-wired to provide the functions discussed below.

[0013] As illustrated in FIG. 2, the four resistive heating elements 50a-50d, 52a-52d are disposed on first and second screed plates 36,38 respectively, and four resistive heating elements 54a-54d, 56a-56d are disposed on the left and right screed plates 40,42 respectively. However, the present invention is not limited to this construction and other numbers of resistive heating elements may be provided for each screed plate.

[0014] The resistive heating elements 50,52,54,56 with subscript a & b are disposed on forward portions of the screed plates 36,38,40,42 and the resistive heating elements 50,52,54,56 with subscript c & d are disposed on rearward portions of the screed plates 36,38,40,42. As used herein throughout, forward refers to the side of the screed plate that is closest in proximity to the paving machine 12, while rearward refers to the farthest away from the paving machine 12. In use, the screed assembly 10 is pulled in the forward direction as indicated by arrow 58 in Fig. 1.

[0015] The heating control system 14 also includes inputs to and outputs from the controller 62. An on/off switch 70, a both/rear-only switch 72 and a warm-up switch 74 provide one set of inputs. Each of the switches 70,72 and 74 selectively connect the electrical power supply 60 to respective input connectors of the controller 62. Temperature switches 80,82,84,86, which are normally open, provide another set of inputs. The function and operation of each of these switches is provided in further detail below.

[0016] The temperature switches 80,82,84,86 are provided, one for the first and second screed plates 36,38 of the main screed 16, and one for the left and right screed plate 40,42 of the left and right screed extensions 18,20. A temperature sensor 90,92,94,96 is provided with each temperature switch 80,82,84,86 to detect the temperature of the corresponding screed plate 36,38,40,42. Temperature switches 80,82,84,86 will close when the detected temperature falls below a first predetermined temperature Ta, e.g., Ta = 250°F, and will open when the temperature reaches a second predetermined temperature Tb, e.g., Tb = 310°F.

[0017] As shown in Fig. 2, eight outputs (1-8) from the controller 62 are provided respectively to eight solenoid relay switches, i.e., four forward output switches 100,102,104,106 and four rearward output switches 110,112,114,116. Two output switches (100,110; 102,112) are assigned for each respective section 30,32 of the main screed plate 16. Similarly, two output switches (104,114; 106,116) are provided respectively for the left and right screed extensions 18,20. The output switches are normally open, and the output switches are closed in response to signals provided from the control-

ler 62. When closed, the switches connect an AC power generator 118 to the respective resistive heating elements 50a-50d, 52a-52d, 54a-54d, 56a-56d, thus selectively heating the screed plates 36,38,40,42 in response to the temperature being below a threshold temperature Ta. Similarly, when the temperature then increases above the second threshold temperature Tb, the closed switch opens and AC power is disconnected from the heating element.

[0018] Each temperature switch 80,82,84,86 controls two corresponding output switches of the associated screed plate. As shown in FIG. 2, temperature switch 80 corresponds to the forward and rearward output switches 100,110 of the first screed plate 36, the forward output switch 100 corresponds to the forward resistive heating elements 50a, 50b and the rearward output switch 110 corresponds to the rearward resistive heating elements 50c, 50d. Thus, the heating of the forward and rearward resistive heating elements on the first screed section 30 is separately controlled by the two respective output switches 100, 110. Similarly, temperature switches 82,84,86 correspond to the second screed section 32 and the left and right screed extensions 18,20 respectively.

[0019] FIG. 3 is a flow chart illustrating a control diagram for the present invention. First, the paving machine is turned on (S1), and either the auto mode or the warm-up mode is turned on (S2). If the warm-up mode is turned on, it is determined whether the rear-only mode is turned on (S3). If yes, all of the rearward heating elements are energized simultaneously (S4) until the screed plates reach a predetermined temperature Tb, e.g., 310°F. If no, all of the heating elements are energized simultaneously (S5) until the screed plates reach a predetermined temperature Tb, e.g., 310°F. After all of the desired heating elements have been heated so that the screed plates reach a predetermined temperature Tb, the controller is automatically set to the auto mode.

[0020] In the auto-mode, it is determined whether the rear-only mode is turned on (S7). If yes, only the rearward heating elements are to be heated. Each rearward heating element is heated in sequence so that the screed plates are heated in sequence. Of course, if only one screed plate is present, this step may refer to only one rearward heating element being heated at a time, whereas if multiple screed plates are present, those rearward heating elements associated with one screed plate are heated together, followed by the rearward heating elements of a second screed plate, etc.

[0021] Next, the temperatures of the screed plates are monitored (S9) and if it is determined that the temperature has fallen below a predetermined temperature Ta, e.g., 250°F, the rearward heating elements of that screed plate are energized (S11). If the temperature is within an acceptable range, the monitoring of the screed plate temperature is continued (S9) until it requires heating.

[0022] A similar method is followed if the rear-only mode is not on in the auto mode. Specifically, all of the heating elements for all of the screed plates are heated in sequence (S12). Again, if only one screed plate is present, only one of the heating elements may be heated at a time. If multiple screed plates are present, those heating elements associated with one screed plate may be heated together. Still further, as with the main screed plate that is divided into two sections, those heating elements associated with one section of the screed plate may be energized first, followed by the energizing of the heating elements of the other section of the screed plate.

[0023] After the screed plates have reached their predetermined temperatures, the screed plate temperatures are monitored (S13). If a screed plate temperature falls below the predetermined temperature T_a (S14), e.g., 250°F, the temperature switch of that screed plate closes and the controller notifies the associated output to energize the corresponding heating elements (S15). While these heating elements are being energized, other temperature switches may close as other screed plate temperatures fall below 250°F. However, these screed plates are not heated until the heating of the previous screed plate is completed. If more than one temperature switch closes at the same time, the controller activates the outputs for only one of the screed plates at a time, in a random order.

[0024] According to the present invention, the controller can be programmed according to the operator's need or the requirements of a particular paving operation. For example, the controller can be programmed to alternately heat each screed plate, or section of a screed plate. Further, the controller can be programmed to heat first one plate, then two plates, or any pre-selected combination of plates in order to provide optimum heating conditions while conserving power.

Industrial Applicability

[0025] In operation, the on/off switch 70 on the controller 62 selectively connects the 24V power supply 60 to the controller 62. When the on/off switch 70 is positioned in an ON position, an automatic mode of the heating control system 14 is initiated. In the automatic mode, the controller 62 is programmed to limit the number of plates or sections that can be activated at a time. For example, only one of two output switches that control heaters in the first and second screed sections 18,20 or left and right screed extensions 30,32 is on at a time. Moreover, the controller 62 can be programmed to allow only one of the output switches that controls right or left hand side heaters of both the extension and main screed plates to be on at one time, i.e., only one extending screed plate or section of the main screed plate can be heated at a time. This control can be variably programmed to have one or more, but fewer than all of the heaters to be on at a time, as would be understood by

one skilled in the art.

[0026] The warm-up switch 74 may be activated if it is desirable to heat more than screed extension plate 40,42 or first and second section plate 36,38 of the main screed plate 16 simultaneously. Such simultaneous heating may be desirable during initial start up of the paving machine 12. When the warm-up switch 74 is activated, the controller 62 turns on all the outputs switches 100,102,104,106,110,112,114,116 at the same time if all the temperature switches 80,82,84,86 are closed. Once the screed plates 36,38,40,42 have reached their predetermined temperatures, the temperature switches 80,82,84,86 open, and the controller 62 returns to automatic mode.

[0027] Also, the warm-up switch 74 overrides the automatic mode. Thus, when the automatic mode is not providing the type of surface finish desired, due to inadequate heating, the warm up mode can be activated. After all the temperature switches open once, the controller 62 may go back to the automatic mode. Alternatively, the warm-up mode may be manually controlled. For example, the warm-up switch 74 also can act as an override for the warm-up mode. Thus, if the operator determines that the appropriate surface finish is being achieved, the warm-up switch 74 can be operated again, and the controller 62 will go back to automatic mode.

[0028] During normal operation the screed plates 36,38,40,42 will cool down and the temperature switches 80,82,84,86 will close. The temperature sensors 90,92,94,96 detect the temperature of the corresponding screed plate 36,38,40,42 and when the temperature falls below a predetermined level, the temperature switch 80,82,84,86 closes. The controller 62 receives a signal that the temperature switch 80,82,84,86 has closed and that the corresponding screed plate 36,38,40,42 should be heated. The controller 62 will energize the resistive heating element or elements corresponding to that screed plate 36,38,40,42 in the time sequenced order in which the temperature switches close. For example, if temperature switch 80 closes first, outputs 100,110 turn on, and then when another temperature switch 84 closes, the controller 62 detects the closing but it waits for outputs 100,110 to turn off before issuing a signal to the appropriate relay to turn on the next outputs 104,114. If multiple temperature switches close while an output is on, then the next outputs associated with a particular screed plate or section will be turned on in the order in which the temperature switch is closed.

[0029] With this automatic mode, only one screed plate 36,38,40,42 can be heated at a time, thus, conserving power for other operations of the paving machine 12. For example, with conventional heating systems several screed plates may be heated simultaneously. This depletes power from other functions, for example, the paving machine speed may slow down, thus slowing down paving operations and affecting road

quality. With the present invention, only a limited amount of power is used to heat the screed plates at any given time, and thus other functions of the paving machines are not affected during normal operation.

[0030] In general, only certain screed plates require heating due to the manner in which the asphalt material interacts with the screed plates. For example, during paving operations, high temperature asphalt material is conveyed from the paving machine 12 onto the roadbed surface. This high temperature asphalt material reaches the center portions (i.e., main screed 16) of the screed assembly 10 first, since the material is conveyed from a central portion of the paving machine 12, and then tends to spread toward the left and right screed extensions 18,20. Since the asphalt material temperature lowers from the time it contacts the main screed 16 to the time it contacts the left and right screed extensions 18,20, the left and right screed plates 40,42 are influenced less by the asphalt temperature. Thus, the left and right screed plates 40,42 tend to require more heating than the first and second screed plates 36,38.

[0031] The both/rear only switch 72 distinguishes the forward outputs 100,102,104,106 from the rearward outputs 110,112,114,116. When the both/rear only switch 72 is off, i.e., "both" is activated, all outputs, forward 100,102,104,106 and rearward 110,112,114,116, are enabled. However, when the both/rear-only switch 72 is on, i.e., "rear-only" is activated, only the rear output switches 110,112,114,116 can be closed.

[0032] For example, if the rear-only switch 72 is on, only the temperature switch 116 for the right screed plate 42 can close, and thus only the rearward resistive heating elements 56c,56d associated with the temperature switch 116 are energized accordingly.

[0033] This feature provides for a more efficient use of the power supply 60 under certain conditions. Namely, those conditions are where only the rearward portion of the screed plate needs to be heated, making it inefficient to energize the forward resistive heating elements. This condition may be preferred due to the manner in which the heated asphalt material interacts with the screed plates. For instance, when the asphalt material is first conveyed from the paving machine 12 onto the roadbed it has a high temperature. This high temperature asphalt contacts the front portions of the screed plates 36,38,40,42, and then reaches the back portions of the screed plates 36,38,40,42 as the screed assembly 10 travels over the asphalt material. However, the temperature of the asphalt material lowers by the time it reaches the back portions of the screed plates 36,38,40,42. Thus, the rear portions of the screed plates 36,38,40,42 are not as influenced by the heated temperatures of the asphalt material, as compared to the front portions of the screed plates 36,38,40,42. Thus, under certain conditions, it may be desirable to only energize the rearward resistive elements in order to conserve power of the paving machine.

[0034] During initial start-up of the paving machine 12,

all of the temperature switches 80,82,84,86 will probably be closed since the screed plate temperatures will be low from lack of use. If the controller 62 is set to automatic mode, there is no priority of turning on the output switches 100,102,104,106,110,112,114,116, and they can be randomly activated. Alternatively, the controller 62 can be programmed to heat the screed plates 36,38,40,42 in a predetermined order.

[0035] Of course, automatic mode can be overridden by initiating the warm-up mode in which case all the outputs would be activated at the same time as described earlier.

[0036] It will be apparent to those skilled in the art that various modifications and variations can be made to the present invention without departing from the spirit or scope of the invention. For instance, additional outputs may be provided to more specifically control each individual heating element, or more or less heating elements may be provided to more specifically control the heating of each screed plate. Thus, it is intended that the present invention cover the modifications and variations of the invention provided they come within the scope of the appended claims and their equivalents.

[0037] Other aspects, objects and advantages of this invention can be obtained from a study of the drawings, the disclosure, and the appended claims.

Claims

1. A heating control system (14) for a screed assembly (10) of a paving machine (12), the screed assembly (10) including a screed plate (36), said heating control system (14) comprising:

a plurality of heating elements (50a,50b,50c, 50d) operatively positioned with respect to the screed plate (36);

an electrical power supply (118);

a plurality of switches, each operable to electrically connect said power supply to one or more of said plurality of heating elements; and
a controller connected (62) to said plurality of switches to selectively operate said plurality of switches to connect said power supply (118) to a one of the plurality of heating elements of the screed plate (50a,50b,50c,50d).

2. The heating control system (14) of claim 1 wherein said selective operation is based on time.

3. The heating control system (14) of claim 1 wherein said selective operation is based on temperature.

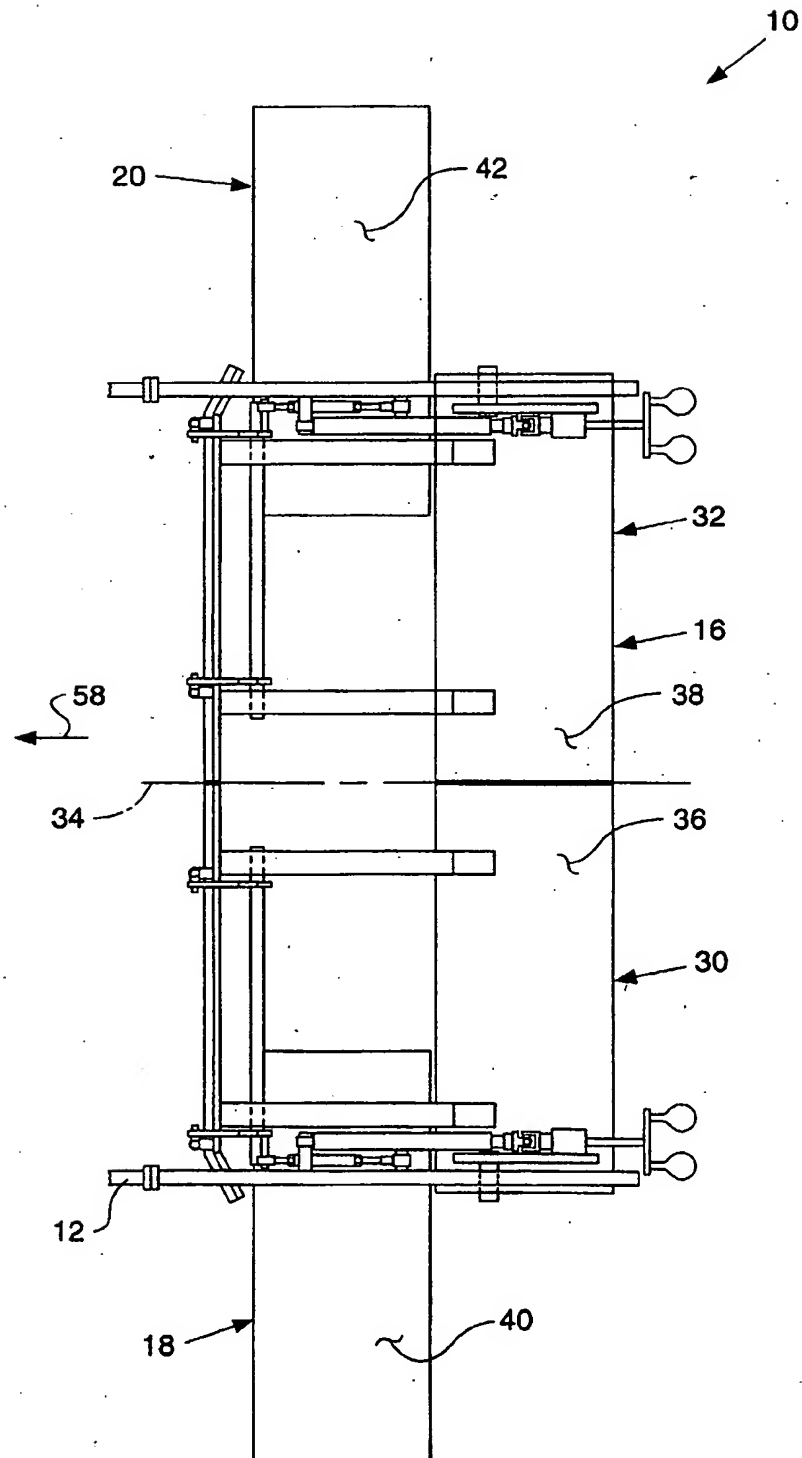
4. The heating control system (14) of claim 1, further including a temperature sensor (90) corresponding to said plurality of heating elements (50a,50b,50c, 50d), said controller (62) being responsive to said

- temperature sensor (90) and operative to automatically adjust the temperature of the screed plate (36) by selectively energizing said one of the plurality of heating elements (50a,50b,50c,50d).
5. The heating control system (14) according to claim 1, wherein power is sequentially supplied to said one of said plurality of heating elements (50a,50b,50c,50d) at a time.
 6. The heating control system 14 according to claim 1, wherein said screed assembly (16) includes a plurality of screed plates (36,38,40,42), and each of said screed plates (36,38,40,42) includes a plurality of heating elements (50a-d,52a-d,54a-d,56a-d), and said controller (62) is configured to automatically operate one of the plurality of heating elements (50a-d,52a-d,54a-d,56a-d) on fewer than all of said screed plates (36,38,40,42) so that only a portion of said fewer than all of said screed plates (36,38,40,42) is heated.
 7. The heating control system (14) according to claim 6, wherein the temperature of only one of said screed plates (36,38,40,42) is adjusted.
 8. The heating control system according to claim 6, wherein each of said screed plates (36,38,40,42) includes a temperature switch (80,82,84,86) to send a signal to said controller (62) when each of said screed plates (36,38,40,42) reaches a predetermined temperature, said controller (62) configured to automatically adjust the temperature of each of said screed plates (36,38,40,42) sequentially according to the chronological order of receiving said temperature switch signal, so that only one of said screed plates (36,38,40,42) is heated at a time.
 9. The heating control system (14) according to claim 1, wherein said controller (62) operates a switch to provide current to said plurality of resistive heating elements (50a,50b,50c,50d) when a temperature is below a first temperature and to block current when a temperature is above a second temperature.
 10. The heating control system (14) according to claim 1, wherein said screed assembly (10) includes a plurality of screed plates (36,38,40,42), and each of said screed plates (36,38,40,42) includes a plurality of heating elements (50a-d,52a-d,54a-d,56a-d), and said controller (62) is configured to automatically operate all of said plurality of heating elements (50a-d,52a-d,54a-d,56a-d) of only a one of said screed plates (36,38,40,42) at a time, so that only one of said plurality of screed plates (36,38,40,42) is heated at a time.
 11. The heating control system (14) according to claim 1, wherein at least one of said plurality of heating elements (50a,50b,50c,50d) is disposed forward on said screed plate (36) and at least one of said plurality of heating elements (50a,50b,50c,50d) is disposed rearward on said screed plate (36), and said controller (62) is configured to only selectively operate said rearwardly disposed resistive heating elements (50c,50d).
 12. The heating control system (14) according to claim 1, wherein said screed assembly (10) is divided into two sections (30,32), and each of said two sections (30,32) includes a plurality of heating elements (50a-d,52a-d), and said controller (62) is configured to energize all of said plurality of heating elements (50a-d,52a-d) of only one of said two sections (30,32) at a time.
 13. The heating control system (14) according to claim 1, further including an on/off input switch (70) wherein said on/off input switch (70) turns on the controller (62) and activates an automatic mode wherein only one of said plurality of resistive heating elements (50a,50b,50c,50d) is energized at a time..
 14. The heating control system (14) according to claim 13, further including a warm-up switch (70) wherein said warm-up switch (70) overrides the automatic mode wherein all of said plurality of resistive heating elements (50a,50b,50c,50d) is energized simultaneously.
 15. The heating control system (14) according to claim 14, further including a both/rear only switch (74) wherein said both/rear only switch (74) enables either all or only rearward placed resistive heating elements (50a,50b,50c,50d) to be energized.
 16. A method for heating a screed assembly (10) of a paving machine (12), the screed assembly (10) including a screed plate (36) and a plurality of resistive heating elements (50a,50b,50c,50d) positioned adjacent to said screed plate (36), comprising the steps of:
 - sequentially and automatically energizing fewer than all of the plurality of resistive heating elements (50a,50b,50c,50d) at a time to achieve a predetermined screed plate temperature.
 17. The method for heating a screed assembly according to claim 16, further including the steps of:
 - de-energizing the energized fewer than all of the plurality of resistive heating elements (50a,50b,50c,50d), and

energizing a next fewer than all of the plurality of resistive heating elements (50a,50b,50c,50d).

18. The method for heating a screed assembly (10) according to claim 16, where one of the plurality of resistive heating elements (50a,50b,50c,50d) is energized at a time. 5
19. The method for heating a screed assembly (10) according to claim 16, further including the steps of; 10
 - energizing all of the plurality of resistive heating elements (50a,50b,50c,50d) simultaneously upon initial start-up of the paving machine (10) to achieve the predetermined screed plate temperature; and 15
 - monitoring the temperature of the screed plate (36) thereafter.
20. The method for heating a screed assembly (10) according to claim 17, wherein the screed assembly (10) includes a plurality of screed plates (36,38,40,42), each having a plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d), further including the step of: 20
 - automatically energizing one of the plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d) at a time in a time sequence that is a function of the time sequence in which each of the screed plates (36,38,40,42) reaches a second predetermined temperature. 25 30
21. The method for heating a screed assembly (10) according to claim 20, before the energizing step including the steps of: 35
 - energizing all of the plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d) of all of the screed plates (36,38,40,42) simultaneously upon initial start-up of the paving machine (12) to achieve the predetermined temperature for all of the screed plates(36,38,40,42); and 40
 - monitoring the temperatures of the screed plates (36,38,40,42) thereafter. 45
22. The method for heating a screed assembly (10) according to claim 16, wherein at least one of the plurality of resistive heating elements (50a,50b,50c,50d) is disposed adjacent to a forward portion of the screed plate (36) and at least one of the plurality of resistive heating elements (50a,50b,50c,50d) is disposed adjacent to a rearward portion of the screed plate (36) including the step of; 50
 - energizing only the plurality of resistive heating elements (50a,50b,50c,50d) disposed adjacent to the rearward portion of the screed plate (36). 55

23. The method for heating a screed assembly (10) according to claim 16, wherein the screed assembly (10) includes a plurality of screed plates (36,38,40,42) each having a plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d), at least one of the plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d) being disposed adjacent to a forward portion of the corresponding screed plate (36,38,40,42) and at least one of the plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d) being disposed adjacent to a rearward portion of the corresponding screed plate (36,38,40,42) further including the step of;
 - energizing only the plurality of resistive heating elements (50a-d,52a-d,54a-d,56a-d) disposed adjacent to the rearward portions of the screed plates (36,38,40,42).



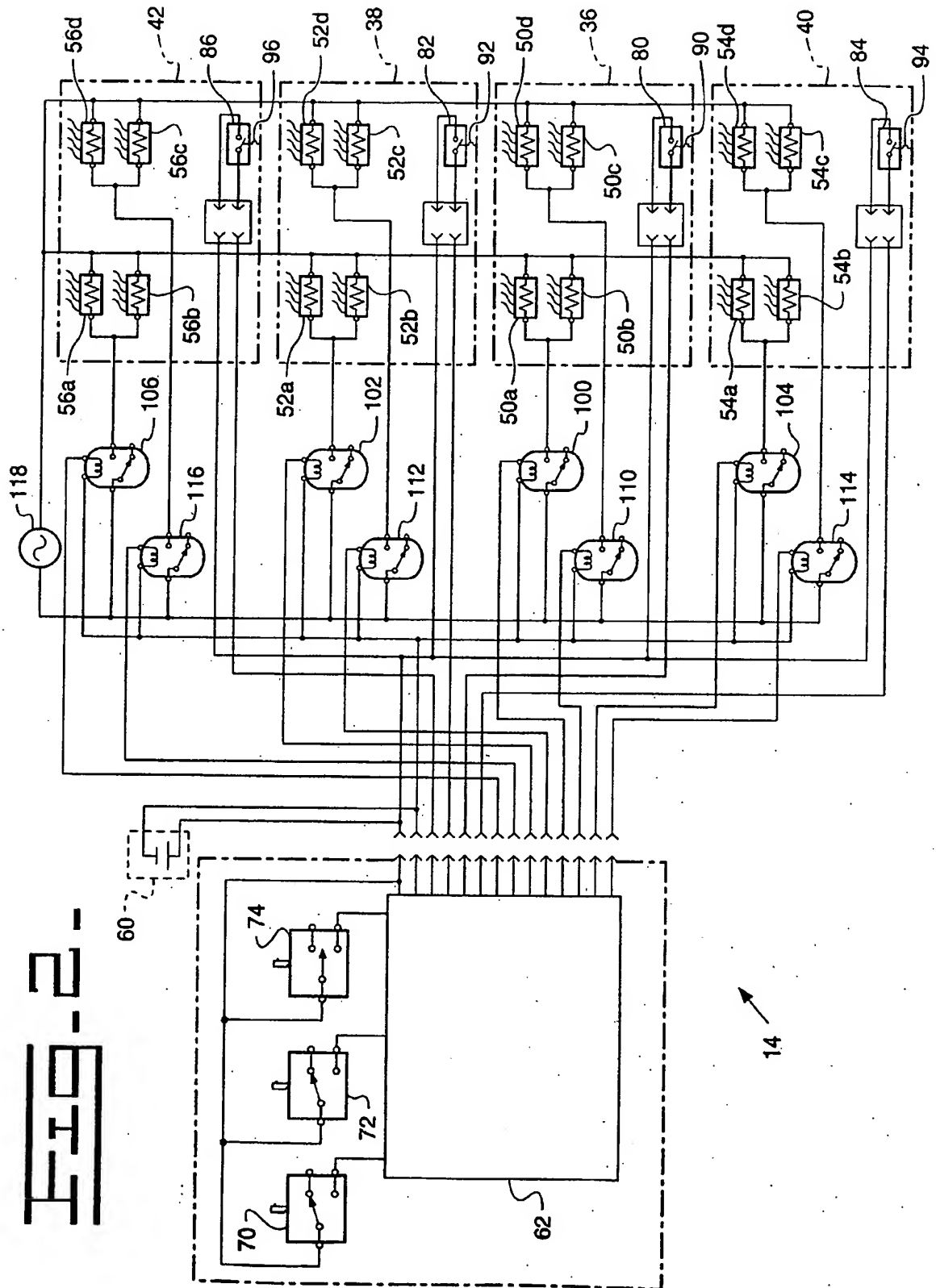


FIG. 3